

Work Order ID 132098

Friday, April 24, 2015 11:41:39 AM

RLC

132098

ASAP

Page 1

Item ID: D2842-042

Revision ID:

Item Name: Step Assembly RH, 206 Float

Start Date: 4/24/2015 Start Qty: 4.00

Required Date: 4/24/2015 Req'd Qty: 4.00

Reference:

2842-042
B132098
REV: B
4
4

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 150424

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.05

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 ***DO NOT OPEN HOLES***
3-Deburr and bevel ends for welding

→ DP 15-5-25

4x

DL 15/4/30

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

4x

DAS
49
9-89

15/05/29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 132098

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Friday, April 24, 2015 11:41:39 AM

Item ID: D2842-042 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Step Assembly RH, 206 Float

Start Date: 4/24/2015 Start Qty: 4.00 *4*

Required Date: 4/24/2015 Req'd Qty: 4.00 *4*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>m13027</i> Large Fab <i>m127865</i>	0.06							
	Memo 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842								<i>BE 15-05-28</i>
	2- OPEN HOLES TO SIZE AS PER DWG (0.250")								<i>7 BE 15-06-01</i>
	3-Grind end cap weld flush								
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							<i>① 15-06-02</i> DAS 9 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							<i>① 15-06-02</i> DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 132098

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly RH, 206 Float
Start Date: 4/24/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/24/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

140

HandFinish

Memo

Hand Finishing

150	QC7-Inspect Chemical Conversion Coat	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

150

QC

Memo

Quality Control

160	Weld per dwg A/R Aluminum rod Batch: <u>MB037</u>	0.00							
-----	---	------	--	--	--	--	--	--	--

160

Large Fab

Memo

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

4X _____ 04/16/6/2

(4) _____ DAG 38 8-89 JUN 03 2015

4 Ø FE 15-06-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
									DAS 9 9-89
									DAS 03 9-89
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
									DAS 9 9-89
									DAS 03 9-89
185	Pressure Wash per QSI005 4.3	0.00							
185									
HandFinish	Memo	0.01							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m 131545</i> Memo START TIME: <i>11:05</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>12:25</i>	0.00 0.01				<i>4</i>	<i>0</i>	<i>15-6-8</i>	<i>DAS 34 9-88</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>4RH</i> <i>15/06/08</i> <i>DAS 15 9-88</i>
210 *210* HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <i>11132039</i>	0.00 0.06				<i>24RH</i>	<i>0</i>	<i>12/06/08</i>	<i>12/06/08</i>

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
220						(4)			
QC	Memo	0.00							
Quality Control									JUN 09 2015
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									JUN 09 2015
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.01							JUN 09 2015
Quality Control									JUN 09 2015

MCS JUN 09 2015

Picklist Print

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Work Order ID: 132098

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Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased		No		100	Each	3,998.000	3	12			
NAS1149C0332R WASHER													

Location	Loc Qty	Loc Code
FP001	2174	
123248	34	X1132262
m130325	2140	
GA	698	
m131618	698	
ST260a	1102	
m131697	1102	
ST271	24	
m131340	24	

12/06/08

D2622-120C

Manufactured No

110 Each 151.9200 1 4

D2622-120C

Step Extrusion

**

Location	Loc Qty	Loc Code
WA003	151.92	
125381	25.92	
130161	126	

4

D2734

Manufactured No

110 Each 89.0000 2 8

D2734

Step End Plate

**

Location	Loc Qty	Loc Code
WA003	89	
130457	29	
130983	60	

8

Dh 15/4/30

BB15-05-27

Picklist Print

Friday, April 24, 2015 11:41:43 AM

Page 2

Work Order ID: 132098

132098

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

D3459-1

Manufactured No

110

Each

41.0000

2

8

D3459-1

Float Step Mounting Plate

BE 15-05-28

Location

Loc Qty

Loc Code

WA003

41

125376

6

126297

6

130003

12

130490

17

2

6

D3459-3

Manufactured No

210

Each

48.0000

2

8

D3459-3

Float Step Mounting Plate

BE 15-05-28

Location

Loc Qty

Loc Code

WA003

48

125129

6

125762

6

126298

6

129735

10

130491

20

8

MS27039C1-07

Purchased No

210

Each

68.0000

3

12

MS27039C1-07

screw

all 15/06/08

Location

Loc Qty

Loc Code

ST283

68

m130566

18

m131624

50

12

Picklist Print

Friday, April 24, 2015 11:41:43 AM

Page 3

Work Order ID: 132098

132098

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1329C3KB130

Purchased

No

210

Each

63.0000

3

12

NAS1329C3KB130

Insert

all 15/06/09

Location

Loc Qty

Loc Code

FP001

23

m129207

21

m130281

2

ST267

40

131677

40

X12

NAS1515H3L

Purchased

No

210

Each

367.0000

3

12

***NAS1515H3I ***

Washer

all 15/06/09

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

272

m127831

48

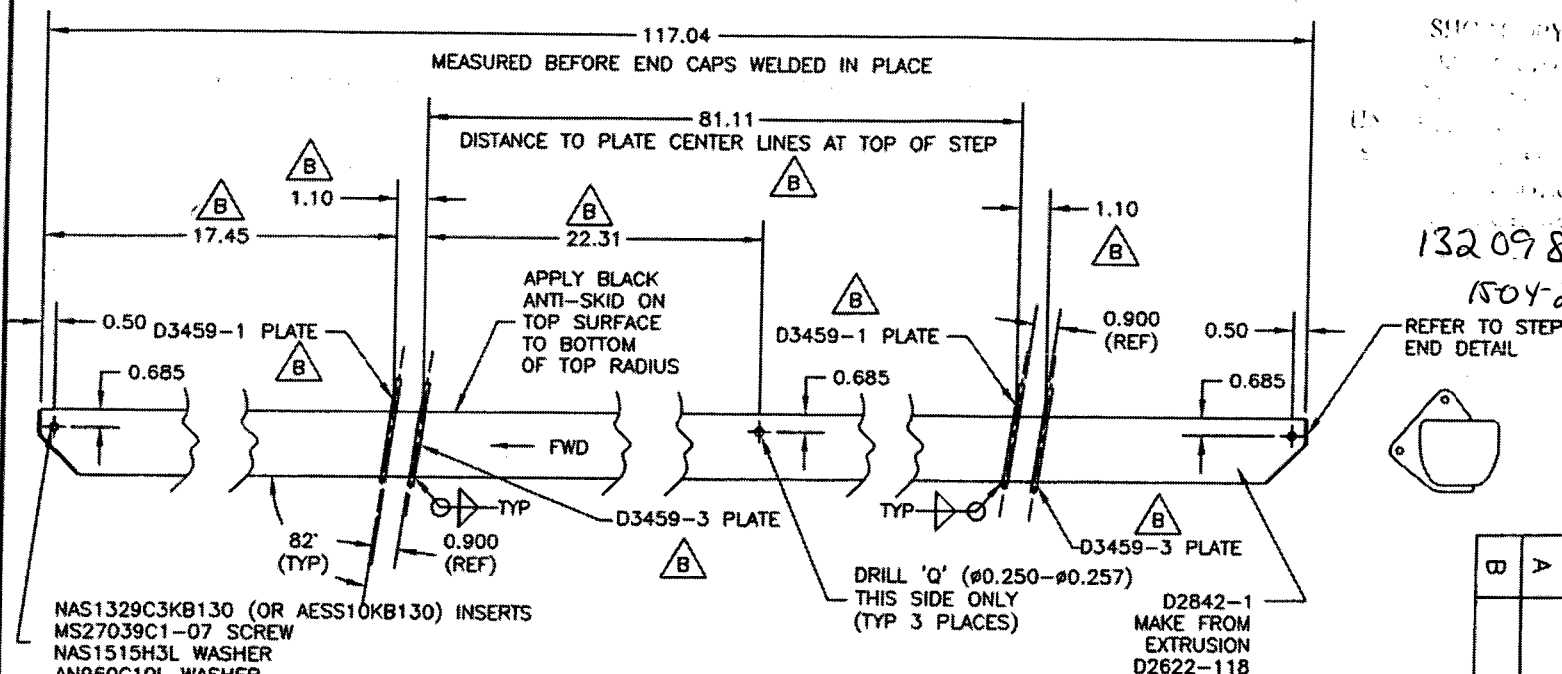
m130726

224

X12



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	DATE 98.10.13	TITLE 206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE NTS
		SHEET 1 OF 1
		REV. B



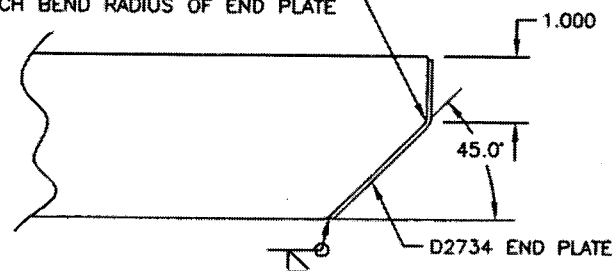
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14